

Date: Thursday, 6/15/2006 1:55:53 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEB
Job Number	: 27589		
Estimate Number	: 10482		
P.O. Number	: N/A	Part Number	: D2923
This Issue	: 6/15/2006 S.O. No. : N/A	Drawing Number	: D2923 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 6/15/2006 Type : LANDING GEAR	Drawing Revision	: A
Previous Run	: 27421	Material	: N/A
Written By	: <i>See Comment Below</i>	Due Date	: 6/30/2006
Checked & Approved By	: <i>06.06.15</i>	Qty:	2 Um: Each
Comment	: Est. B 02.07.26 Updated Location RF		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D26005108

Extrusion 'I Beam' thin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

D2600-5-108 Extrusion 'I Beam' thin

Batch: *024410 IT 06-06-22*

2.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Cut D2600-5 Extrusion to length as per Dwg D2923.

Deburr ends

IT 06-06-22

3.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Drill pilot holes in web as per Dwg D2923 using drill jig DT8481

2- Open holes to finish size as per Dwg D2923.

3- Deburr

IT 06-07-14

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-07-14 (2)

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

IT 06-07-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 19 Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:55:53 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 27589

Part Number: D2923

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 6-7-18

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 66

DP 6-7-18

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.19

Job Completion



U 06.07.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

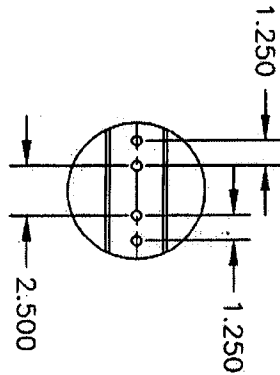
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

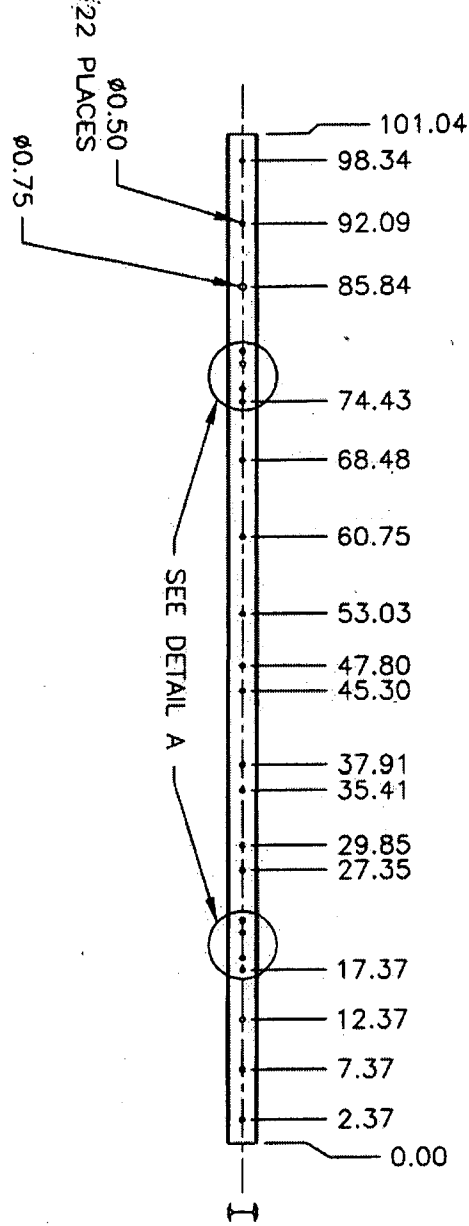
QA: N/C Closed: _____ Date: _____

NO. 27589
 ORDER
 WORK NOTICE
 SHEET 1 OF 1
 UNCONTROLLED COPY
 REVISIONS
 REVISION TO
 SHOP COPY

MAKE FROM D2600-5 EXTRUSION
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DETAIL A
 SCALE 1:9



RELEASED
 00.05.11

DESIGN RF	CHECKED RF	APPROVED RF	DRAWING NO. D2923	REV. A	SHEET 1 OF 1	SCALE 1:18	DATE 99.10.14	TITLE WEB	NEW ISSUE	A	99.10.14



DART Aerospace USA, INC.
 BELLEVUE, WA